

Work Order ID 142246

Monday, March 07, 2016 7:32:47 AM

142246

Page 1

Item ID: D412-761-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Modified Latch Mechanism, LH

Start Date: 3/3/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/9/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: *MC*Date: **MAR 07 2016**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-761

E

100

Document Control

0.00

DAS

6

9-89

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-761-043 CHG002

*MC***MAR 07 2016**

5

DAS
28
9-89**MAR 07 2016**

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

5

DAS
28
9-89**MAR 07 2016**

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

5

DAS
28
9-89**MAR 07 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 142246

Monday, March 07, 2016 7:32:47 AM

142246

Page 2

Item ID: D412-761-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Modified Latch Mechanism, LH

Start Date: 3/3/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/9/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-043 Location:FG020								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

5

DAS
28
9-88

MAR 07 2016

MCS

MAR 07 2016

MCS

MAR 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

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Page 1

Work Order ID: 142246

142246

Parent Item: D412-761-043

D412-761-043

Parent Item Name: Modified Latch Mechanism. LH

Start Date: 3/3/2016

Required Date: 3/9/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP REV:B
11.11.29 AS PER DSI9580 DD VRF:EC IPP REV:C 12.07.23
ECN12-568 chg002 DD VRF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3589-041 5 *D3589-041* Latch Assembly		Manufactured	No			110	Each	3.0000	1	5		DAS 6 9-89	DAS 27 9-89

**

141589x2

DAS
28
9-89

Location	Loc Qty	Loc Code
ST	2	
139591	2	
ST234	1	
137721	1	

D3589-047 5 *D3589-047* Fwd Guide		Manufactured	No			110	Each	5.0000	1	5		DAS 6 9-89	DAS 27 9-89
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DAS
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9-89

Location	Loc Qty	Loc Code
ST044	5	
137647	1	
141465	4	

D3589-049 5 *D3589-049* Aft Guide		Manufactured	No			110	Each	5.0000	1	5		DAS 6 9-89	DAS 27 9-89
---	--	--------------	----	--	--	-----	------	--------	---	---	--	------------------	-------------------

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Location	Loc Qty	Loc Code
ST044	5	
137749	1	
141603	4	

MAR 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Picklist Print

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Work Order ID: 142246

Parent Item: D412-761-043

Parent Item Name: Modified Latch Mechanism, LH

142246

D412-761-043

Start Date: 3/3/2016

Start Qty: 5.00

Required Date: 3/9/2016

Required Qty: 5.00

MS16997-24

Purchased

No

110

Each

34.0000

2

10

**

5 *MS16997-24*
SCREW

DAS
28
9-89

Location

Loc Qty

Loc Code

ST316

34

m132656

14

m133316

20

10

NAS1149DN632J

Purchased

No

110

Each

807.0000

2

10

**

5 *NAS1149DN632.J*
Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST264

700

m134370

700

ST265

107

m133860

107

10

MS21042L06

Purchased

No

110

Each

146.0000

2

10

**

5 *MS21042I 06*
Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

146

m134063

46

m134294

100

10

DAS
28
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DAS
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DAS
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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

REFERENCE ONLY

DAS
28
9-89

DART AEROSPACE LTD.

IIN-D412-761

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6.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD KITS

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
								D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
								D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
X								D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X							D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
		X	1					D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1	1		X					D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1	1			X				D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1					X			D412-761-049	ARMREST KIT, LH
	1					X		D412-761-051	ARMREST KIT, LH
							X	D412-761-141	VENT KIT
		1						D3589-041	LATCH ASSEMBLY
		1						D3589-047	FORWARD GUIDE
		1						D3589-049	AFT GUIDE
		2						MS16997-24	SCREW
		2						MS21042L06	NUT
		2						NAS1149DN632J	WASHER (OR AN960JD6L)
			1					D3676-1	LARGE BUBBLE WINDOW
			1					D3678-1	PLACARD
			1					D3678-3	PLACARD
			1					D3700-1	INBOARD WINDOW DOUBLER
			1					D3700-3	OUTBOARD WINDOW DOUBLER
			1					D3701-1	FLOOR DOUBLER
			1					D3702-1	FORWARD DOUBLER
			1					D3703-1	AFT DOUBLER
			1					D3703-3	AFT CORNER DOUBLER
			1					D3703-5	AFT CAP
			1					D3704-1	ESCUTCHEON
			1					D3704-3	ESCUTCHEON
			1					D3708-1	ANGLE
			1					D3708-3	ANGLE
			1					D3709-1	ANGLE
			1					D3709-3	ANGLE
			1					D3802-1-135	SEAL
			1					DT9458	CUTTING TEMPLATE
			26					AN3-7A	BOLT
			26					MS21042L3	NUT
			1					MS24694-C5	SCREW (OR MS24694-S5)
			1					MS24694-C13	SCREW (OR MS24694-S13)
			1					NAS43DD3-24	SPACER
			52					NAS1149D0363J	WASHER (OR AN960JD10)

(CONTINUED ON PAGE 11)

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Revision: E
Date: 12.12.07